

**LISTING OF CLAIMS:**

This listing of claims will replace all prior versions, and listing, of claims in the application.

1. (Currently amended) A method for controlling a slitter-scorer apparatus, comprising the steps of:

supplying a paperboard sheet along a feed line; and

moving a slitter/scorer including at least one of a slitter and a scorer in at least one of a vertical direction by a mechanism for vertically moving said slitter/scorer and a widthwise direction by a mechanism for horizontally moving said slitter/scorer to an operative level where a surface of the paperboard sheet is processed thereby,

wherein each of said mechanism for vertically moving said slitter/scorer and said mechanism for horizontally moving said slitter/scorer includes a servo motor,

and when said slitter/scorer moves from a first widthwise position of a first operative position to a second widthwise position of a second operative position, said slitter/scorer is caused to start moving only in the vertical direction while a level of said at least one of said slitter/scorer is between a bottom surface of the paperboard sheet and a top surface of the paperboard sheet, and said slitter/scorer is moved simultaneously in the vertical direction and in a cross machine direction which said cross machine direction is oriented from said first widthwise position to said second widthwise position so that said slitter/scorer moves diagonally toward said second cross machine position before said slitter/scorer moves only in the vertical direction and after said slitter/scorer moves only in the vertical direction.

2. (Cancelled).

3. (Previously Presented) A method as recited in claim 1, wherein said slit/scorer is moved simultaneously in said vertical direction and in said widthwise direction so that said slit/scorer moves diagonally toward said second widthwise position when said slit/scorer moves from said first widthwise position of said first operative level to said second widthwise position of said second operative level.

4. (Previously Presented) A method as recited in claim 3, wherein said diagonal movement of said slit/scorer occurs while said slit/scorer is positioned in the paperboard sheet.

5. (Previously Presented) A method as recited in any one of claims 3 or 4, wherein a path of movement of said slit/scorer forms a plurality of straight lines which define a generally convex shape which is oriented in such a way that the nearer said straight lines come to a peak of the generally convex shape, the more said straight lines are separated from said surface of the paperboard sheet.

6. (Previously Presented) A method as recited in any one of claims 3 or 4, wherein a path of movement of said slit and/or scorer forms a curved line which defines a generally convex shape which is oriented in such a way that the nearer the curved line comes to its peak, the more the curved line is separated from said surface of the paperboard sheet.

7. (Previously Presented) A method as recited in claim 1, wherein said slit has an anvil positioned relative to a slit blade of said slit such that the paperboard sheet will be clamped therebetween, and said operative level being adjusted in accordance with the depth of

the wear of said anvil during a setup step of said operative level so that said slitter blade penetrates into said anvil.

8. (Cancelled).